

# Work Order ID 57562

April 8, 2010 10:25:55 AM



Page 1

Item ID: D3207-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3207

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3207

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

MAT NOT PULLED

HB 10-4-13

*(16)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-4-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Solar 13*

*(X15)*

*Pho ->*

W/O: 57562

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/01/13	#120	Took Qty +1 For QC inspection template	S	10/01/13	+1		S 10/01/13

Part No: D3207-2 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 57562**

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April 8, 2010 10:25:56 AM

Item ID: D3207-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Form 1/2 of stack for D3207-2 as per Dwg D3207 Identify as D3207-2

SB 10/04/22

(14)

1

PTO

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subtotal

(4)

Quality Control

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

(14)

10/04/20

Hand Finishing

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3207-2 PAR #: N/A Fault Category: Sm Fab NCR: Yes No DQA: AB Date: 10.05.03  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AB Date: 10/05/03

NCR: <u>57562</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B:			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/04/22</u>	<u>130</u>	<u>1 piece crack</u>  <u>R.C process</u>	<u>AB</u> <u>as per</u>	<u>Scrap + destroy</u>	<u>AB</u> <u>10/04/22</u>	<u>AB</u> <u>10.04.22</u>	<u>AB</u> <u>as per</u>	<u>AB</u> <u>10.04.22</u>

NOTE: Date & initial all entries

**Work Order ID 57562**

April 8, 2010 10:25:56 AM



Page 3

Item ID: D3207-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

0.00

⇒ M 10/04/27

14

φ

Memo

START TIME: 10:16am □ OVEN TEMPERATURE:  
10:45pm □ FINISH TIME: 320°C

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

(14) φ 10-4-27

180



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 202

0.00

0.00

Memo

10-4-28 14 SP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57562**

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Page 4

Item ID: D3207-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/08/10

Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/29 KJ  
BY 10-4-29  
(14)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April 8, 2010 10:25:55 AM

Page 1

Work Order ID: 57562

Parent Item: D3207-2

Parent Item Name: Bracket

Comments: IPP ☐ A ☐ 04.04.15 ☐ New issue ☐ KJ/RF ☐

IPP Rev:B Now On Waterjet 08-01-02 JLM Verified By:DD

Start Date: 4/08/10

Required Date: 4/16/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	47.0000	1.5053	<del>2.5</del>		



2024-T3 .050 sheet

1B 10-4-13

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT22

47

111381

32

112291

11

113189

4

113189

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/22								

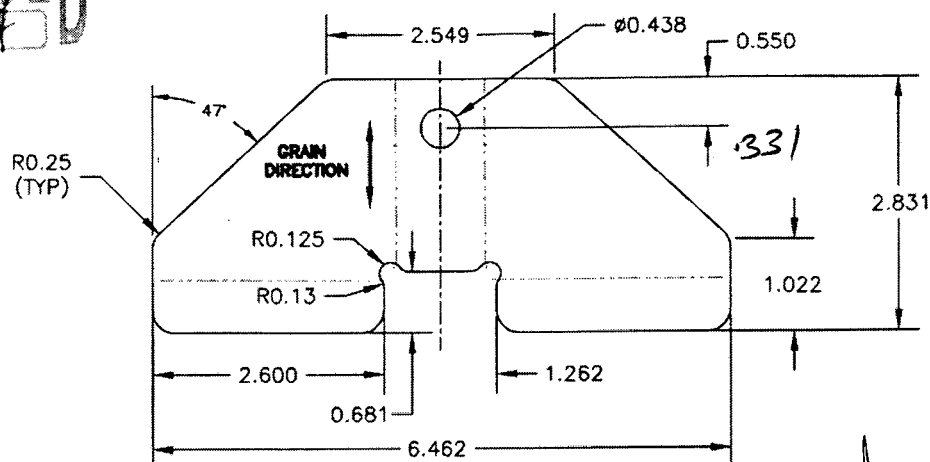
**NOTE:** Date & initial all entries



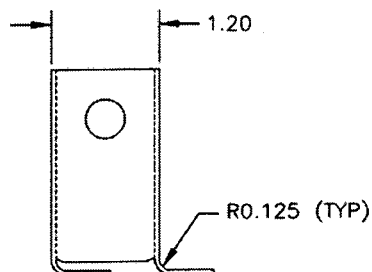
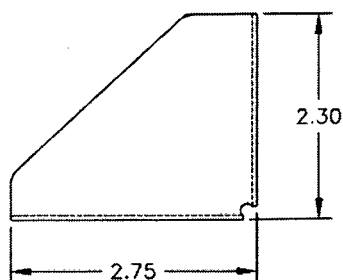
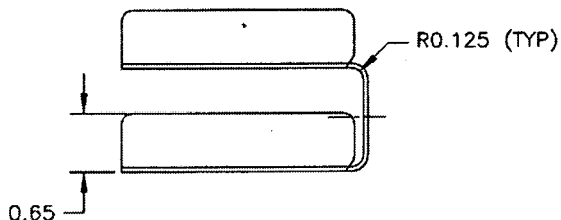


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED  
04.04.05



**D3207-1/-2 FLAT PATTERN**



**D3207-1 BEND DETAIL (SHOWN)  
D3207-2 OPPOSITE**

**D3107-1/-2 BRACKET**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

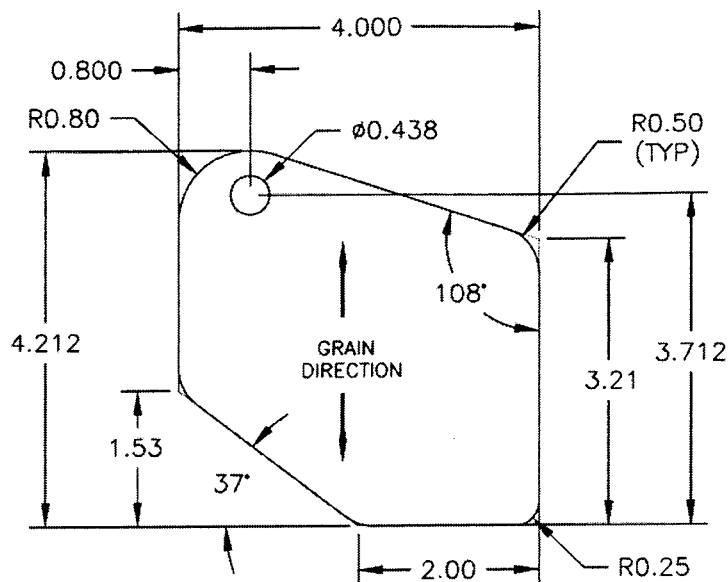
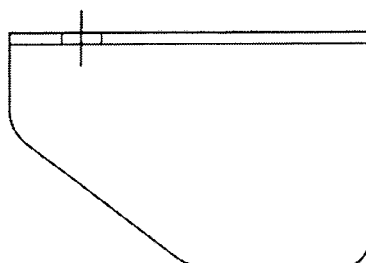
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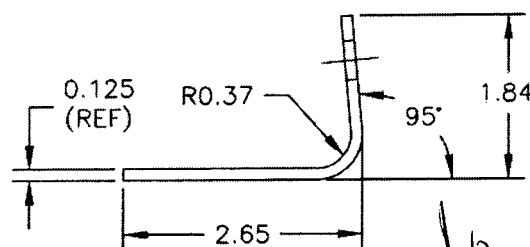
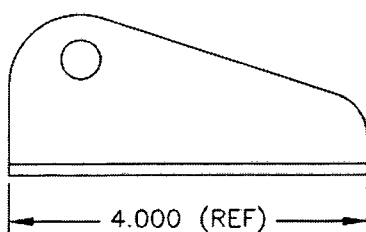


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CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED  
04.01.05



**D3207-3 FLAT PATTERN**



ulb 37562

**D3207-3 BEND DETAIL**

**D3207-3 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

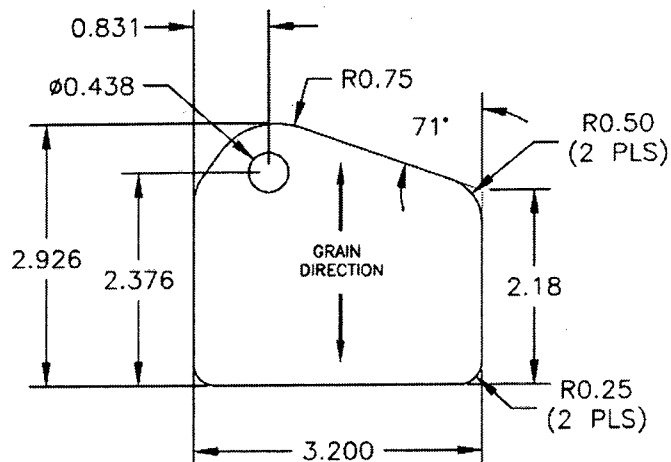
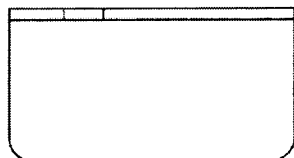
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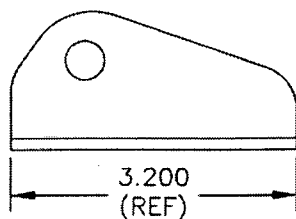


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CHECKED H	APPROVED H	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

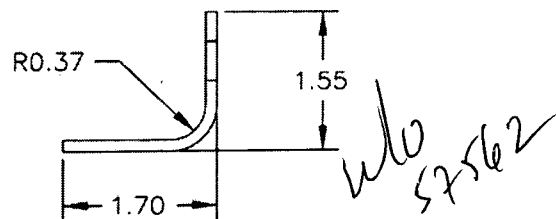
RELEASED  
04.04.05 H



**D3207-5 FLAT PATTERN**



**D3207-5 BEND DETAIL**



**D3207-5 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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